



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4977-1
Job Sheet 166975



Part No: D4977-1

Job Qty: 2 ea

Part Name: Bracket, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/20/17

Job Tracking No:

Due Date: 10/23/17

Created By: Victoria Michaud-Febrille

Type: ~~Stock~~ *gao*

Description:

Customer: Leonardo S.p.a (CAGUS03)

Piazza Monte Grappa 4 Rome, RM, 00195 Italy ph:39 0331 229294 fx:+39 0331 229730.

Note: DWG REV D SHEET 1 IPP REV: A NEW ISSUE JFS 13/11/22 VERIFY BY: JLM IPP REV: B 14.06.16 AS PER
DWG REV: C DD VERF: JLM IPP REV: C RQ 16.09.07 DWG. REV: D VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/20/17	10/20/17	0.00	0.00	Start Up Machining		<i>J.F.</i>
100	Bandsaw	2 pcs	10/20/17	10/20/17	0.00	0.25	Bandsaw1		<i>J.F.</i>
110	CNC Vertical Machining	2 pcs	10/23/17	10/23/17	0.00	12.94	HAAS 5 Axis		<i>J.F.</i>
117	QC	2 pcs	10/23/17	10/23/17	0.00	0.00	QC8		<i>Fk 17-12-3</i>
120	Outsource	2 pcs	10/23/17	10/23/17	0.00	0.00	Outsource4		
130	Packaging	2 pcs	10/23/17	10/23/17	0.00	0.00	Packaging2		<i>DAS</i>
140	QC	2 pcs	10/23/17	10/23/17	0.00	0.00	QC5		<i>38</i>
180	Packaging	2 pcs	10/23/17	10/23/17	0.00	0.00	Packaging3		<i>9-88</i>
190	QC21-SA	2 Ea	10/23/17	10/23/17	0.00	0.00	QC21		<i>DEC 15 2017</i>

Part Op 100 - CUT BLANKS 2.63" LONG

Descriptions: 110 - Mill as per folio FB496 and dwg. D4977. Folio rev: _____ Dwg. rev: _____ Deburr.

120 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

180 - ***IDENTIFY BY STAMPING P# AND REV***

38553

DEC 04 2017

DAS
13
9-88

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6B1.750X04.500	0	14	0	0

FM 134164-2

Part Specifications

5016385

Specifications could not be found.

DQA: _____ Date: _____

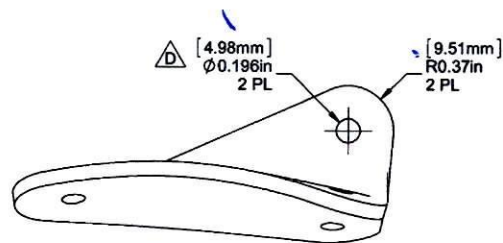
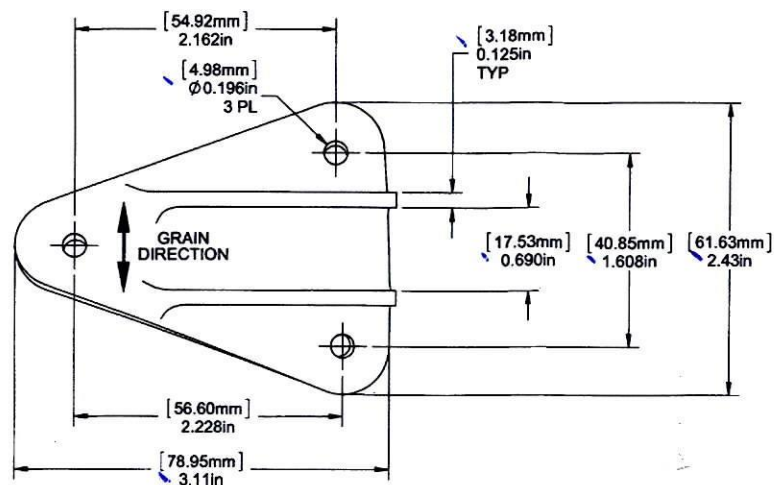


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

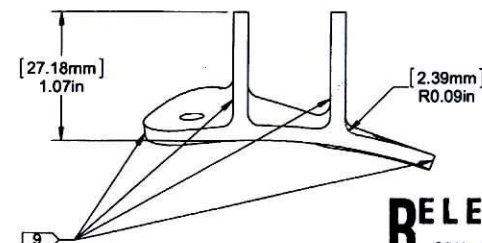
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com S016389																																																																															
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%;"> <tr> <td>☐ F</td> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ E</td> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ C</td> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ C</td> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ C</td> <td></td> <td></td> <td></td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ C</td> <td></td> <td></td> <td></td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ C</td> <td></td> <td></td> <td></td> <td>☐ Drawing</td> </tr> <tr> <td>☐ C</td> <td></td> <td></td> <td></td> <td>☐ Finish</td> </tr> <tr> <td>☐ C</td> <td></td> <td></td> <td></td> <td>☐ Misread</td> </tr> <tr> <td>☐ C</td> <td></td> <td></td> <td></td> <td>☐ Turning Sequence</td> </tr> </table>				☐ F	☐ Crushing	☐ Countersink	☐ Off-set	☐ Positioned Wrong	☐ E	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Outside Dimensions	☐ C	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Over/Under tolerance	☐ C	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Part Incorrect	☐ C				☐ Part Lost/Missing	☐ C				☐ Part Moved	☐ C				☐ Drawing	☐ C				☐ Finish	☐ C				☐ Misread	☐ C				☐ Turning Sequence
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OTHER : _____																																																																															



D4977-1 BRACKET, LH

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-1", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-1.d.IGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER



RELEASED
2014-07-28

D	REVISED CLEVIS HOLE DIMENSIONS FROM Ø0.191 to Ø0.196 (ZN B6-1, ZN B5-2)	AK	14.07.14
C	REVISE NOTE 6) ZN (A8-1, A8-2)	AK	14.06.05
B	MODIFIED BRACKET GEOMETRY	AK	14.05.02
A	NEW ISSUE	DC	13.11.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4977	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

DQA: _____ Date: _____



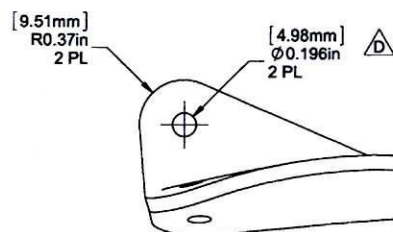
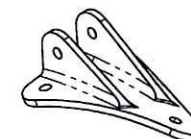
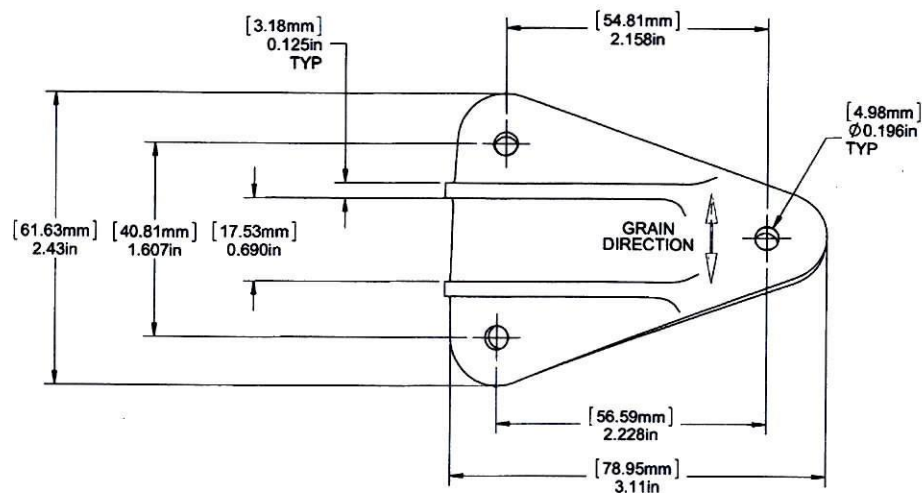
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

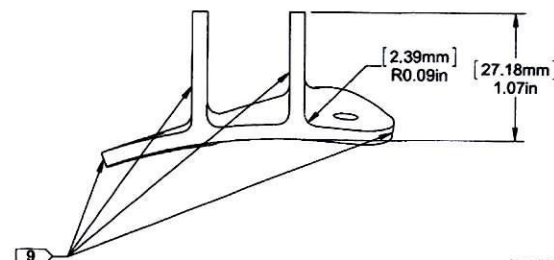
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

8 7 6 5 4 3 2 1

**D4977-2 BRACKET, RH****NOTES:**

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-2", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-2.d.IGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER



RELEASED
2014-07-28

APPROVED

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4977	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038553

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required							
5	167512	D5355-041	Aft Clamp Assembly Issue P/O to ATG : Black Anodize as per Dwg D5355 Certification of Conformity is required.	Firmed	12/11/17	4 pcs	0 pcs	4 pcs	\$5.61/pcs	\$22.44
6	166975	D4977-1	Bracket, LH Issue P/O to ATG : Hard Black Anodize, PRIME AS PER dwg D4977	Firmed	12/11/17	2 pcs	0 pcs	2 pcs	\$10.90/pcs	\$21.80
7	168020	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.3300	Firmed	12/11/17	7 pcs	0 pcs	7 pcs	\$20.45/pcs	\$143.15
8	168226	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.3300	Firmed	12/11/17	4 pcs	0 pcs	4 pcs	\$20.45/pcs	\$81.80
9	169137	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.3300	Firmed	12/11/17	1 pcs	0 pcs	1 pcs	\$20.45/pcs	\$20.45
10	165562	646.9710	Body Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.9700	Firmed	12/11/17	40 pcs	0 pcs	40 pcs	\$16.85/pcs	\$674.00
11	165646	646.9810	Deflector Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.9800	Firmed	12/11/17	4 pcs	0 pcs	4 pcs	\$49.60/pcs	\$198.40
12	168227	646.3311	RH Half - Upper Cutter Assembly Issue P/O to ATG : Hard black anodize/Prime as per dwg 646.3311	Firmed	12/11/17	4 pcs	0 pcs	4 pcs	\$0.011/pcs	\$0.04
13	168021	646.3311	RH Half - Upper Cutter Assembly	Firmed	12/11/17	8 pcs	0 pcs	8 pcs	\$0.011/pcs	\$0.09

DAS
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9-89

12-12-17



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914269

Date: 11-Dec-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	OUR TRUCK
Quantity	Description
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.
5 ea	Part: 646.3311 Rev: NC RH Half Upper Cutter Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22118 PO: PO038553 Line: 12
2 ea	Part: 646.9710 Rev: D Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 22120 PO: PO038553 Line: 14
2 ea	Part: RBT103311-101 Rev: Sleeve Tool Job: 22122 PO: PO038553 Line: 16
2 ea	Part: D4977-1 Rev: D Bracket, LH Job: 22101 PO: PO038553 Line: 6
CERTIFICATE OF CONFORMANCE A.T.G. Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>11/12/2017</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G. Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may Made in Canada.	

DA:
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9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914269

Date: 11-Dec-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			